

Work Order ID 144367

April 13, 2016 3:45:00 PM

144367

Page 1

Item ID: D3825-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly (Basket End, Lid)
 Start Date: 5/13/2016 Start Qty: 4.00 ***4*** 6 **SA** Cust Item ID:
 Required Date: 5/18/2016 Req'd Qty: 4.00 ***4*** 6 Customer:
 Reference:

Approvals: Process Plan: **SA** Date: 1 6 0 4 1 3 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3825	C
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100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.96

1- cut D3825-3 rib as per dwg D3825

2- drill hole (3/16") in D3825-3 using DT9822 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825

A/R S.S. Rod Batch: **B133750**

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

16-05-05
 6 6/16/05
 6 6/16-5-12

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>6x</u>		DAS 43 9-89	MAY 12 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<u>6x</u>		DAS 43 9-89	MAY 12 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>W004</u> Memo LOCATION WA004	0.00 0.04				<u>6x</u>		DAS 43 9-89	MAY 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER : ☐							

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Page 3

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly (Basket End, Lid)

Start Date: 5/13/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.40

Quality Control

MC5 MAY 13 2016

MC5 MAY 12 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Picklist Print

April 13, 2016 3:45:00 PM

Page 1

Work Order ID: 144367

144367

Parent Item: D3825-043

D3825-043

Parent Item Name: Rib Assembly (Basket End, Lid)

Start Date: 5/13/2016

Required Date: 5/18/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC
REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-1

Manufactured No

100

Each

8.0000

1

4

DAS

43

9-89

MAY 10 2016

D2327-1

Spacer Bushing

** B 132529 → 6

Location

Loc Qty

Loc Code

WA004

8

132529

8

D4021-9

Manufactured No

100

Each

113.0000

2

8

DAS

43

9-89

MAY 10 2016

D4021-9

Bushing

** B 141539 → 12

Location

Loc Qty

Loc Code

WA004

113

141539

113

M304TS0.750W.065

Purchased

No

100

f

1,255.787

2.125

8.947368

**

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA004

1255.787362

m132970

35.88

m132924

172.177362

m133412

553

m133757

494.73

9

C

16709/05

16-05-08

DQA: _____ Date: _____

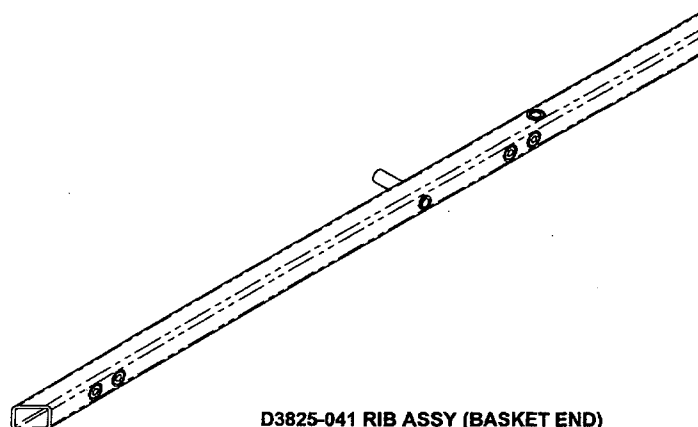
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

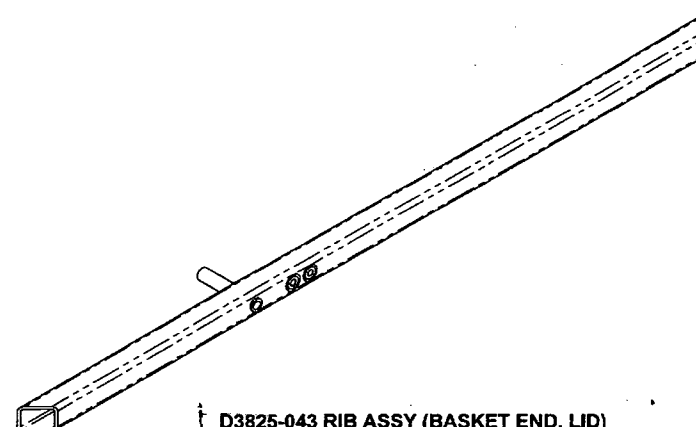
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3825-041	RIB ASSEMBLY (BASKET END)
		X	D3825-043	RIB ASSEMBLY (BASKET END, LID)
1		1	D2327-1	SPACER BUSHING
2	1		D2327-3	SPACER BUSHING
3	1		D3759-1	BUSHING
4	1		D3825-1	RIB
5		1	D3825-3	RIB
6	4	2	D4021-9	BUSHING



D3825-041 RIB ASSY (BASKET END)



D3825-043 RIB ASSY (BASKET END, LID)

RELEASED
2012-08-03
wp

20160413
144367
SLA

NOTES:

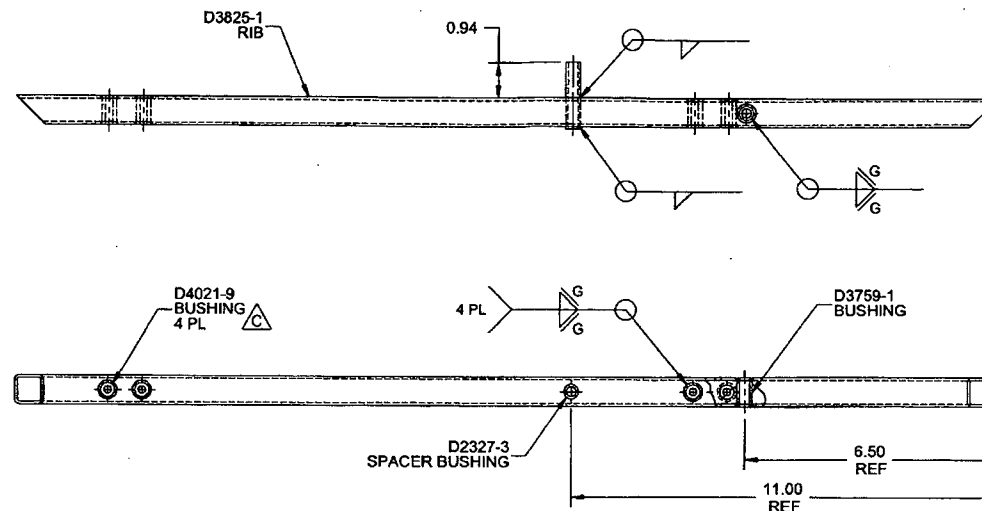
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
- 8) WELDING: PER DART QSI 004

C	QTY(4) D4021-9 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3759-1. CORRECTED DIM (2N B3-4): WAS 14.875. REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS.	MB	12.07.18
B	QTY(5) FOR D3759-1 WAS QTY(1): AFFECTS D3825-041-1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043-3. REASON: PART 10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	h		
DRAWN	h		
CHECKED	h		
MFG. APPR.	h		
APPROVED	h		
DE APPR.	h		
DATE	12.07.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. C
SHEET 1 OF 4
TITLE **RIB ASSY (BASKET END)** SCALE NTS

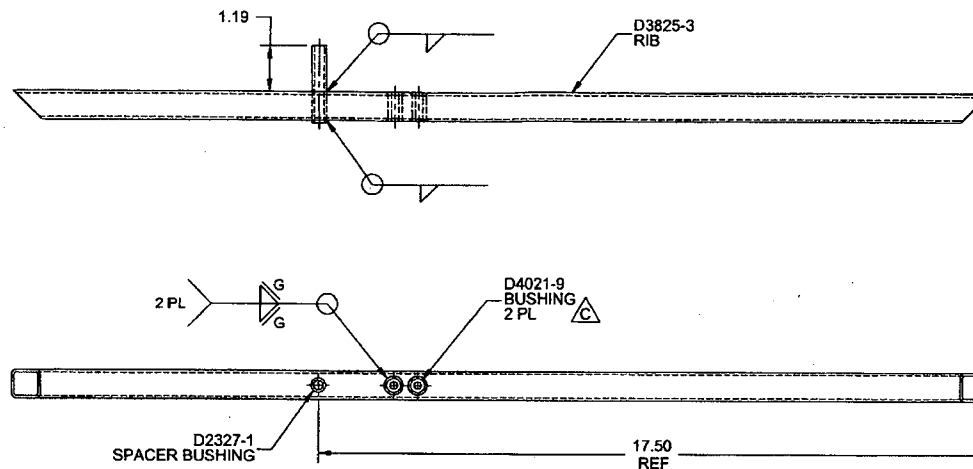
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D3825-041 RIB ASSY (BASKET END)

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2012-03-03
JNP

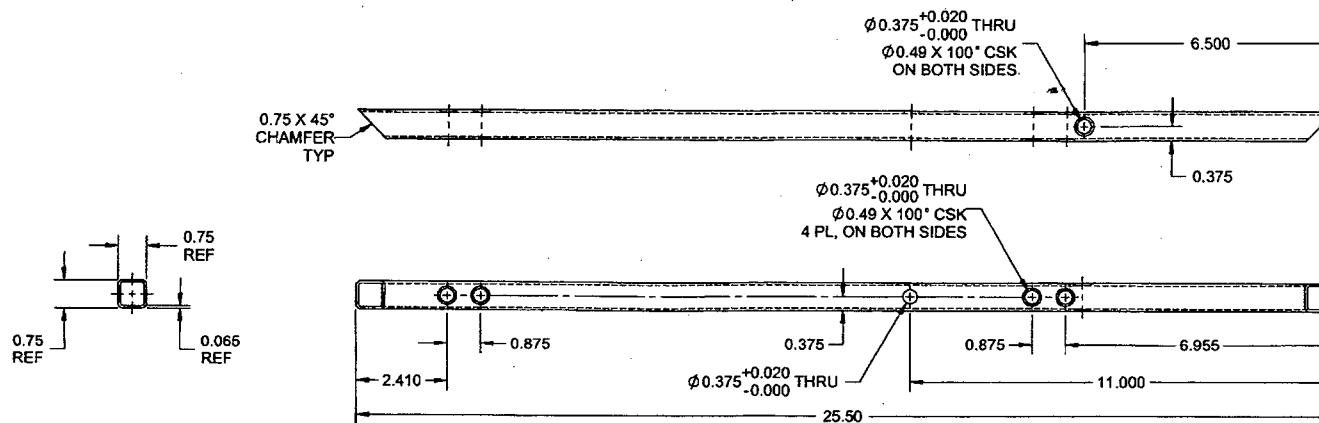
DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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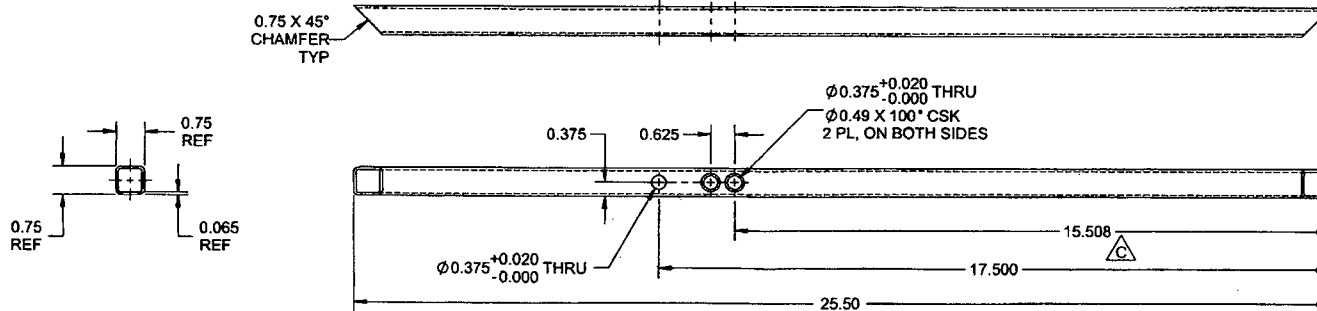
D3825-043 RIB ASSY (BASKET END, LID)

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WHP

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MFG. APPR.	<i>[Signature]</i>	D3825	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET END)	NTS
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D3825-1 RIB



D3825-3 RIB

RELEASED
2012-08-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

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CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3825 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		RIB ASSY (BASKET END) NTS
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